

Blue

Date: Tuesday, 14/10/2008 1:10:26 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG ASSEMBLY
Job Number : 42567	
Estimate Number : 11745	
P.O. Number :	Part Number : D3394043
This Issue : 14/10/2008 S.O. No. :	Drawing Number : D3394 REV A - BLUE
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision :
Previous Run : 41711	Material :
Written By :	Due Date : 31/10/2008 Qty: 20 Um: Each
Checked & Approved By : <u>JUL 08-10-14</u>	
Comment : Est Rev: A New Issue 06-01-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0735 f(s)/Unit Total : 1.4700 f(s)

D2423 Lug Extrusion

Batch: B33513 B33310 C 202110/14

2.0	BAND SAW	BAND SAW
-----	----------	----------



cut at Metec

Comment: BAND SAW
Cut Blank to .850"

3.0	OUTSIDE SERVICE	OUTSIDE SERVICES
-----	-----------------	------------------



Comment: Sub-Contracting OUTSIDE SERVICES
Send Blanks To: Metec/Mast Precision Machining
P/O: 7393
Machine D3394-3 as per Dwg D3394

C 202110/16 (20)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage

P 4/10/28 (19)

5.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

50210/28 (19)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JS

08-10-30

(X19)

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment:

-PRIME

B109083

-SPRAY PAINT DELFLEET BLUE

B105918

-CLEAR DELFLEET

B109816

ml

08 11 10

(19)

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

BT 08-11-11

9.0

MS3548993

GROMMET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty Part Number Description
2 MS35489-93 Grommet

Batch

M106168

8/11/11

(19)

SP

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3394

EP 08/11/11

(19)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-11-11

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST. 420

JS 08/11/11

(X19)

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Drawing Name: LUG ASSEMBLY

Job Number: 42567

Part Number: D3394043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/12 *fg*

Comment: FINAL INSPECTION/W/O RELEASE

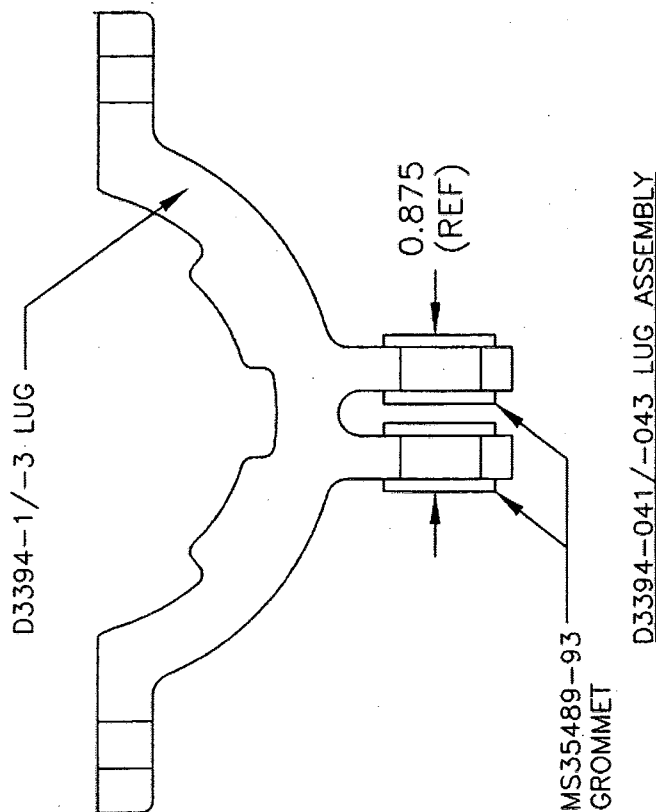
Job Completion



u 08.11.12



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED AH	APPROVED AH	DRAWING NO. D3394	REV. A SHEET 1 OF 3
DATE 05.02.14		TITLE LUG	SCALE 1:1
A	05.02.14	NEW ISSUE	



PARTS LIST FOR D3394-041/-043 LUG ASSEMBLY

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X		D3394-041	LUG ASSEMBLY
	X	D3394-043	LUG ASSEMBLY
1		D3394-1	LUG
2	1	D3394-3	LUG
	2	MS35489-93	GROMMET

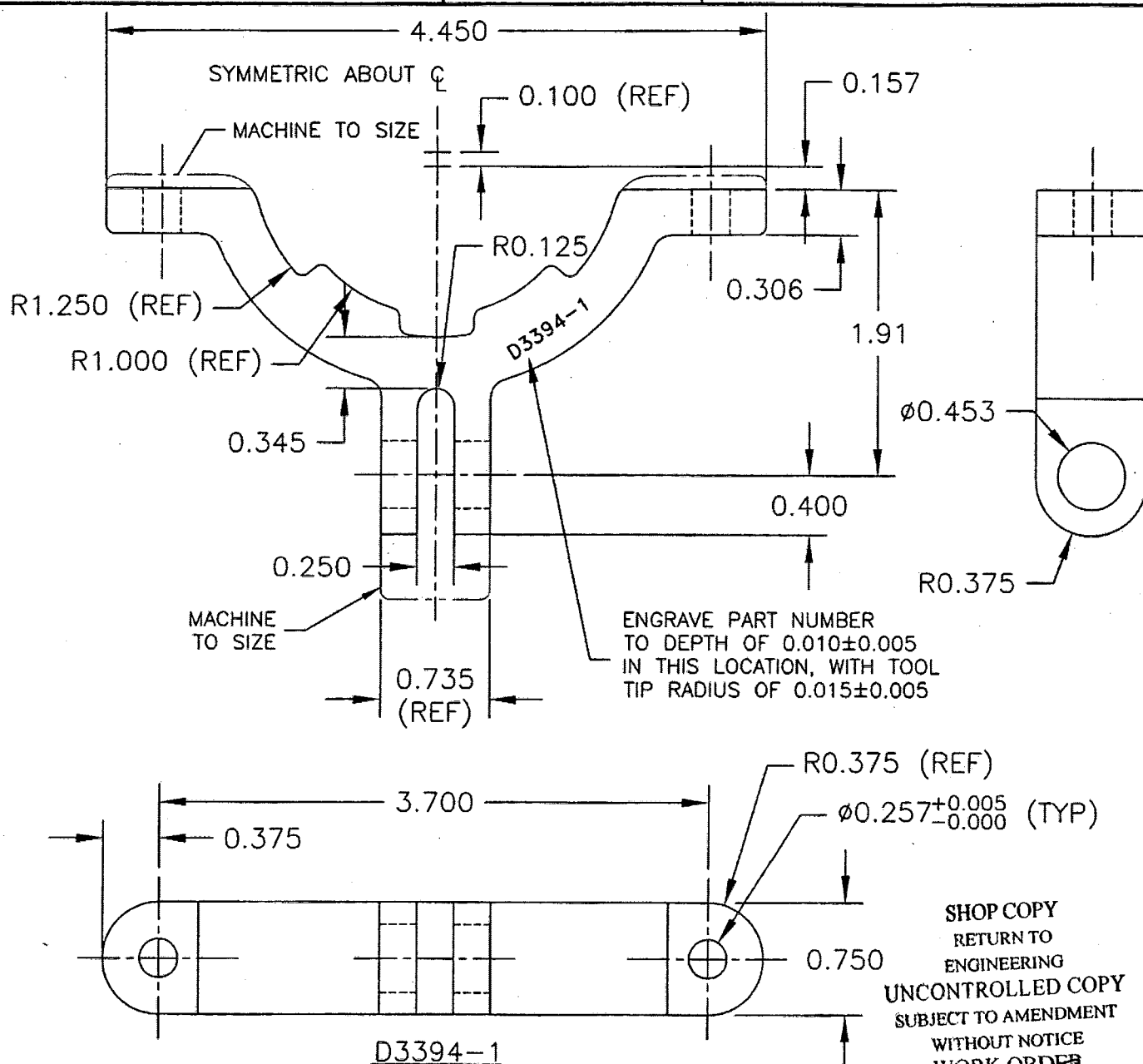
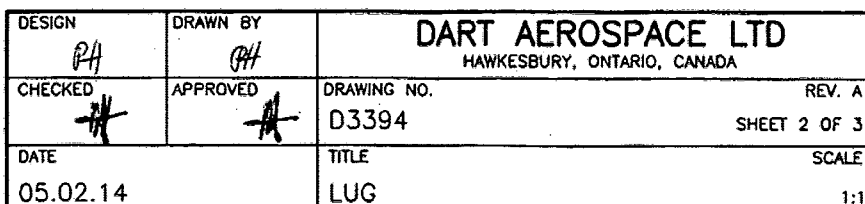
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05.11.14

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- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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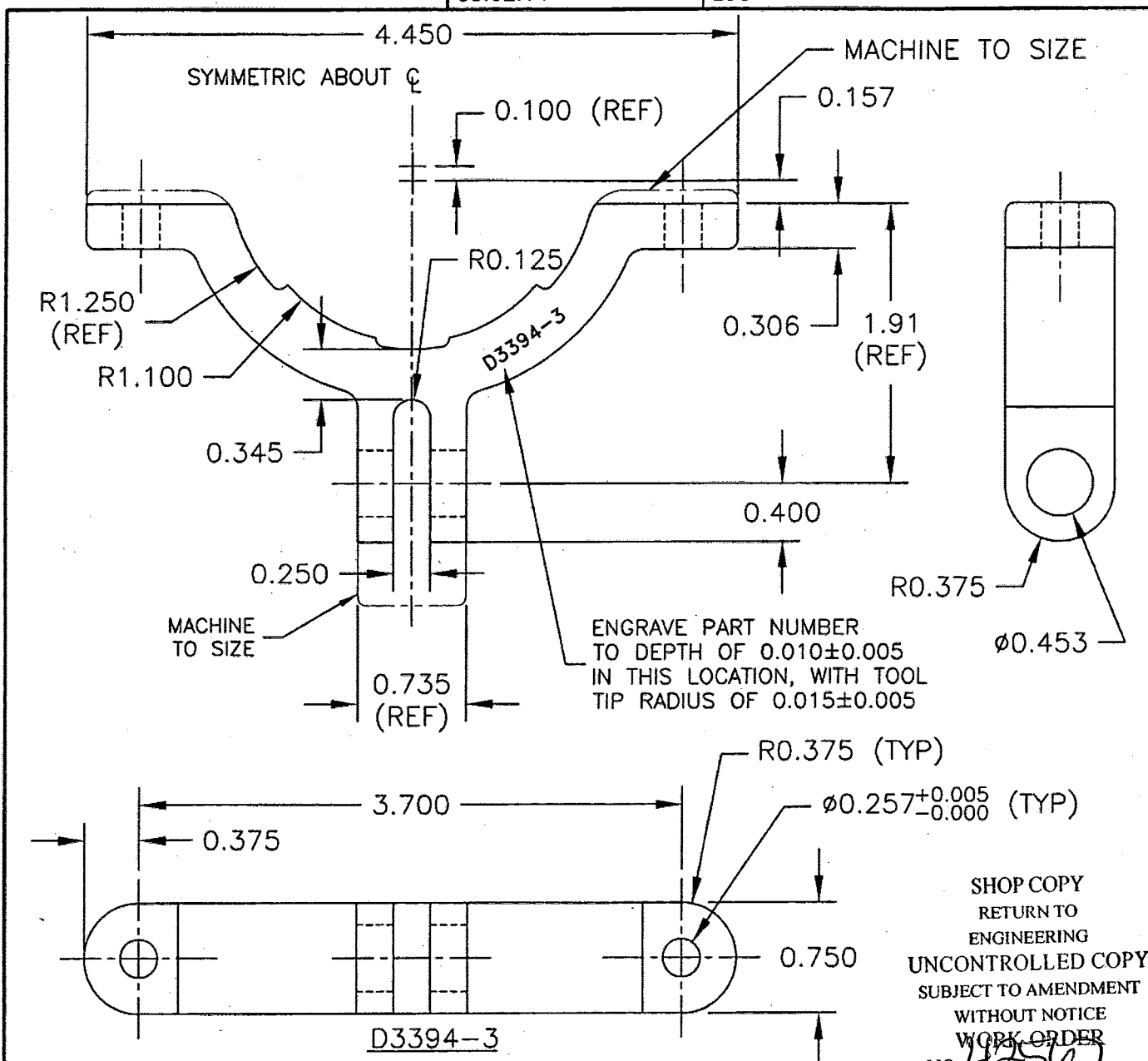
05.11.14

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				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	SHEET 3 OF 3
				D3394	
DATE	05.02.14			TITLE	SCALE
				LUG	1:1



D3394-3 NOTES

- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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05.11.14

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CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

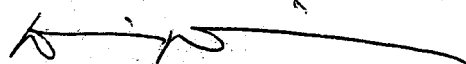
<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>MATERIAL BATCH NUMBER</u>	<u>P.O. NUMBER</u>
16 19	2731-7	Lug	D2423 B33310	7383
	3394-3	Lug	D2423 B33310	7383

MATERIAL: supplied by DART

S. 08/10/29

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Denise Robinson

Vankleek Hill, October 28, 2008